

Work Order ID 66973

Thursday, March 03, 2011 9:01:11 AM



Page 1

Item ID: D2600-3-120

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Round 3" 350

Start Date: 3/3/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 80.00

Customer:

Reference:

Approvals: Process Plan: CZ Date: 11/03/03 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2600	Rev D1

100 0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13593 ☐ a) Extrude as per Dwg D2600 ☐ b) Material: 6061-T6 (QQ-A-200/8) ☐ c) Minimum yield tensile strength = 35 ksi ☐ d) Minimum ultimate tensile strength = 40 ksi ☐ e) Minimum elongation = 8% ☐ f) Order at 120" long ☐ g) Bon L Canada Inc. tool #

CZ 11/03/03 (80)

110 0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Purchasing (84)

120 0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

8/10/12

(XSE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66973

Thursday, March 03, 2011 9:01:11 AM



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Item ID: D2600-3-120

Accept



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Revision ID:

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Start Date: 3/3/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *Back Hall*

0.00



Packaging

Memo

0.00

Packaging

84

BB
11/04/11

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

MVF

11-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 9:01:08 AM

Page 1

Work Order ID: 66973



Parent Item: D2600-3-120



Parent Item Name: Extrusion Round 3" 350



Start Date: 3/3/2011

Required Date: 3/31/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D: 02.09.10 Added DSK 066 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120P  Extrusion Round 3" 350		Purchased	No			100	Each	0.0000	1 	80		3/4/11 (84)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>FCP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

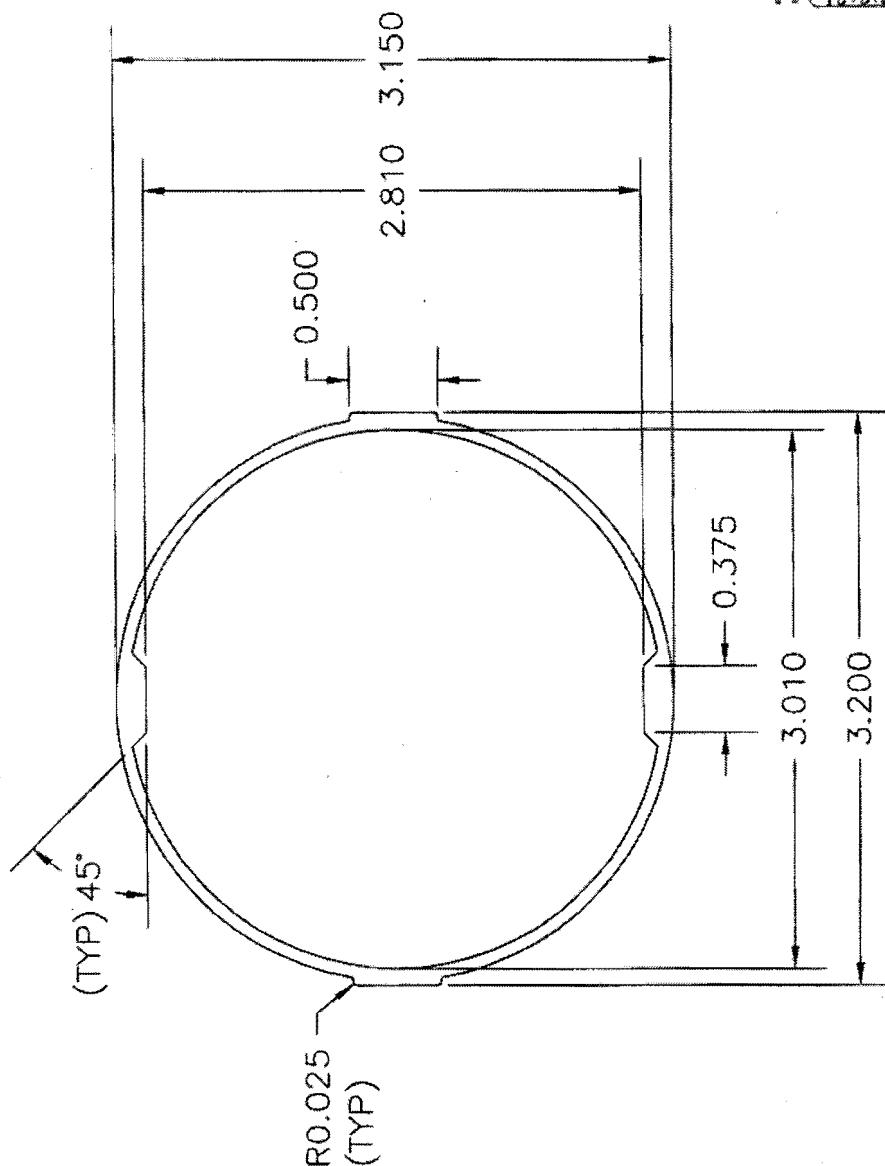
CL11/03/03

W10:66973



DESIGN <i>DB</i>	DRAWN BY <i>DB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>ST</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BON L DIE # 89712.1 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

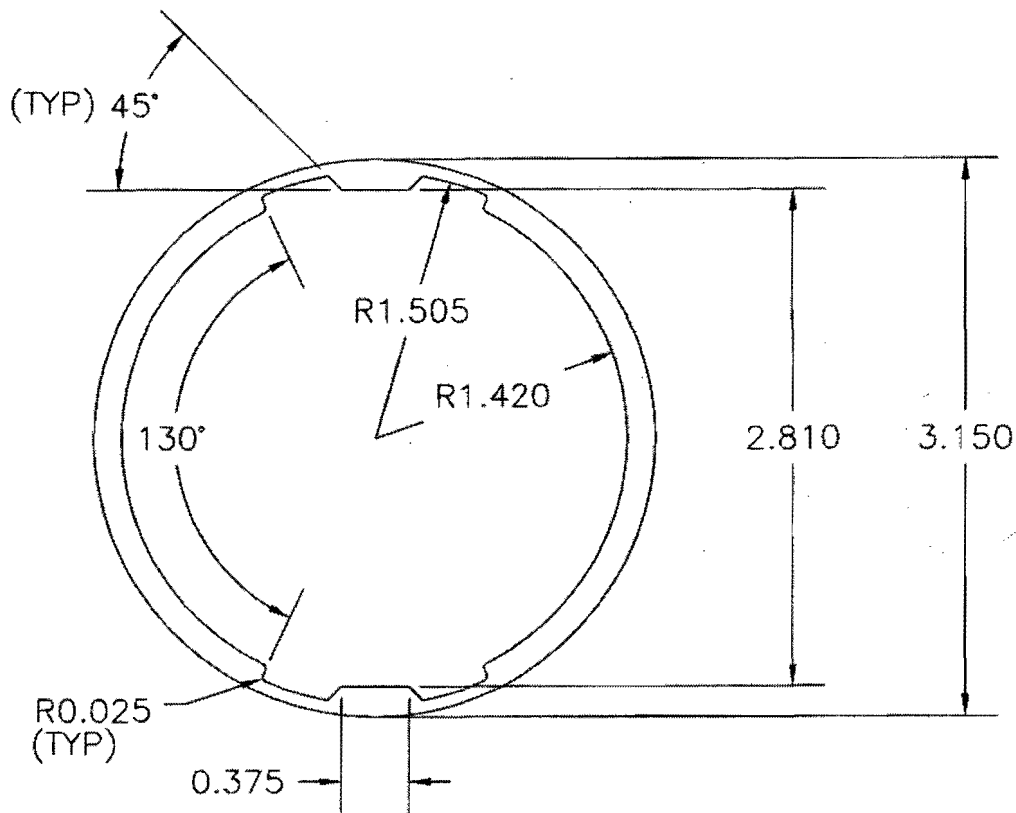


W10:66973

DART



DESIGN	<i>DM</i>	DRAWN BY	<i>DM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>KE</i>	APPROVED	<i>CH</i>	
DATE	98.08.20	TITLE	D2600	REV. D
		EXTRUSION		SHEET 3 OF 5
				SCALE 1:1



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

W10.86973

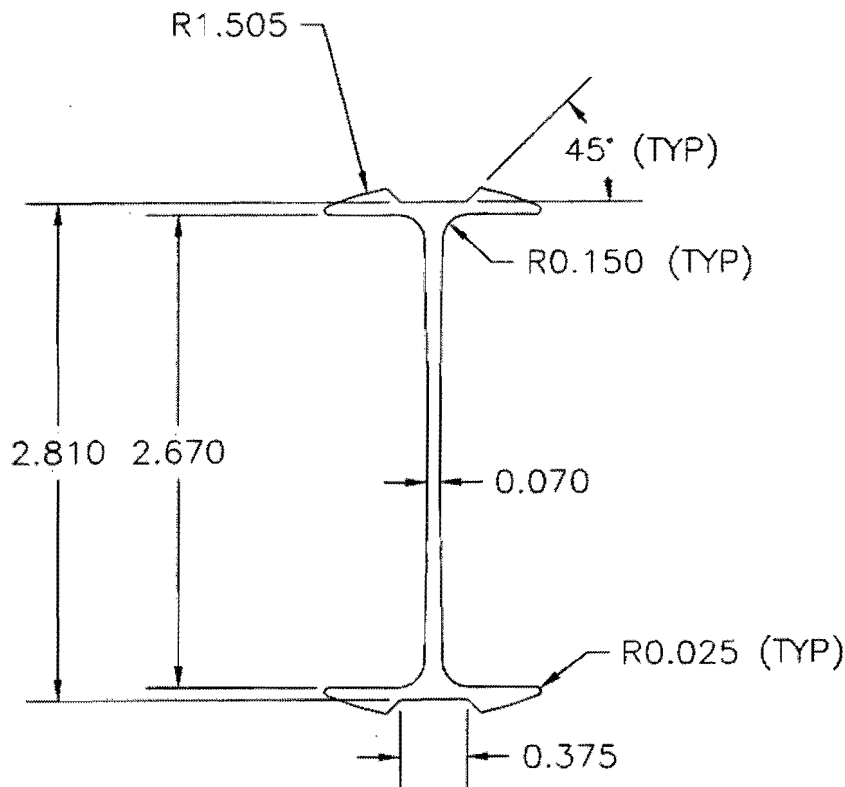


RELEASED
98.8.25 DS



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2600	SHEET 4 OF 5
98.08.20		TITLE	SCALE
		EXTRUSION	1:1

RELEASED
98.8.25. BS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



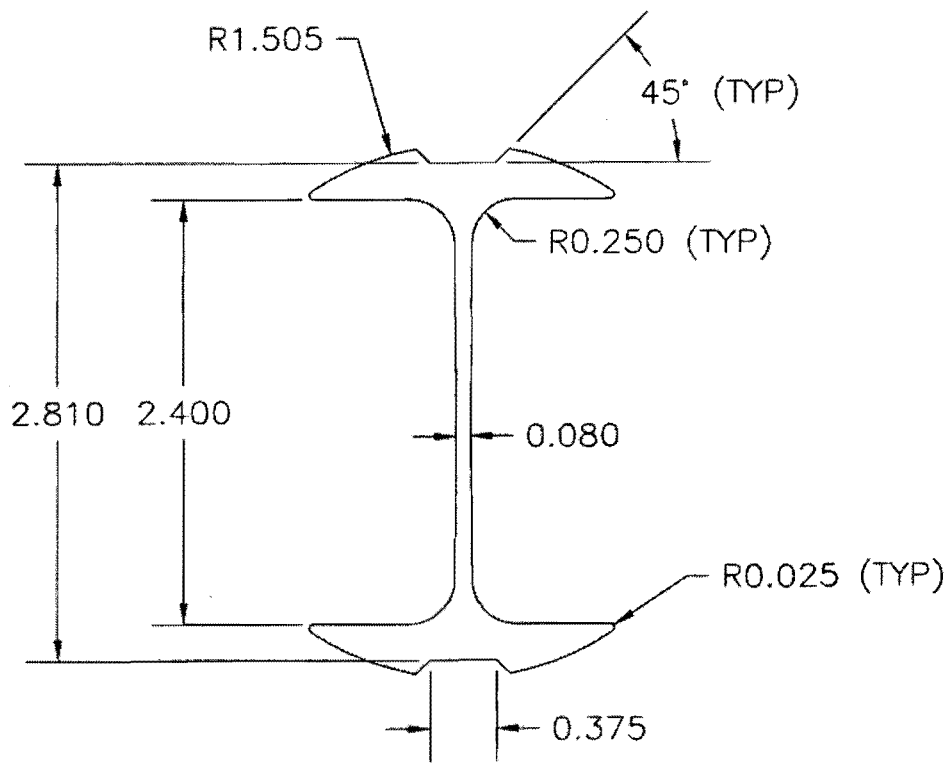
W10: 66973

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2600	REV. 0
DATE 98.08.20		TITLE EXTRUSION	SHEET 5 OF 5
			SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



010.66773



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13593

Purchase Order Date 3/3/2011

PO Print Date 3/3/2011

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

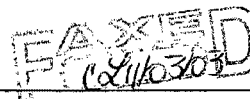
FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2600-3-120P	Extrusion Round 3" 350	4/4/2011 Yes	80.00 Each	Yours ppd	\$47.0220	\$3,761.76
		Special Inst: EXTRUDE AS PER DWG D2600 REV. D1 B66973 MATERIAL: 6061-T6 AS PER (QQ-A- 200/8) MINIMUM YIELD TENSILE STRENGTH = 35 KSI MINIMUM ULTIMATE STRENGTH = 40 KSI MINIMUM ELONGATION = 8% 120 " LONG SIGNATURE TOOL DIE # 897122					
2	D2622-120CP	Extrusion	4/4/2011 Yes	120.00 Each	Yours ppd	\$27.0660	\$3,247.92

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/3/2011



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
04/05/2011	5257947	69112	1
Cust. PO	B/L No.	Lot	Date
13593	000506	800692	04/05/11

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No.	Part No.	Item Description	Cust Part
001	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	1,382 LBS		
Net Qty	1,351 LBS	84 PCS	2 PKGS
Specification		Die Descr	
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HREW
MPA / KSI	MPA / KSI			
302.1 / 43.8	282.8 / 41.0	12.8	0.0	95

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
0.65	0.27	0.26	0.08	0.90	0.07	0.08	0.02

Sublot 7

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

R. Petersen, QA Manager Signature Aluminum Canada Inc



ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU
04-05-11MANIFEST NUMBER / N° DE BODEREAU
000506SALES ORDER NUMBER / N° DE COM
69112

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

PHONE: 613-632-5200			PHONE: 613-632-5200			LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES			
						PIC	GOLDEN	138		M. BATES			
CUSTOMER ID / ID DU CLIENT		ORDER DATE / DE LA COM		CUSTOMER PO NUMBER / CLIENT PO Nombre			JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE		
46024		03/03/11		13593									
				BILL OF LADING NUMBER / NO. DE CONNAISSEMENT			CARRIER / TRANSPORTEUR		M. BATES		DLB		
				000506			GOLDEN						
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL		UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION		NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
					CUSTOMER PART NUMBER / NUMÉRO DE RÉFÉRENCE DU CLIENT	LENGTH / LONGUEUR	FABRICATION DESCRIPTION / DESCRIPTION DE FABRICATION						
						CUTTING TOLERANCE / Tolérance de coupe	SHIPPING TOLERANCE / EXPÉDITION TOLERANCE						
001	1,279		LB		DAA-897122-1	6061			2	1,382	1,351	LB	
	580		KG		D2600-3-120					627	613	KG	
	80		PC				Min: 0 % Max: 0 %				84	PC	
							800692 / 102982		1	635	619		39 PC
							800692 / 102983		1	747	732		45 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below
by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in
accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

		Continued	
TOTALS			

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